



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5305-1

Job Sheet 180276



Part No: D5305-1

Job Qty: 10 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 15.09.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/31/18	0.00	0.00	Start Up Waterjet		SC 18/07/18
100	Waterjet	10 pcs		7/31/18	0.00	0.48	Waterjet1		SC 18/07/18
120	QC	10 pcs		7/31/18	0.00	0.00	QC8		38
130	Small Fab	10 pcs		7/31/18	0.01	0.34	Small Fab-9		9-89 DAS
140	QC	10 pcs		7/31/18	0.00	0.00	QC5		38
150	HandFinish	10 pcs		7/31/18	0.00	0.20	HandFinish1		DR 18/11/18
160	QC	10 pcs		7/31/18	0.00	0.00	QC7-5		NOV 15 2018
170	SprayPaint	10 pcs		7/31/18	0.00	0.57	Spray Paint		AR 18/11/18 9-89
180	QC	10 pcs		7/31/18	0.00	0.00	QC14		38
190	Packaging	10 pcs		7/31/18	0.00	0.00	Packaging3-2	L6056	AR 18-11-22
200	QC21-SA	10 Ea		7/31/18	0.00	0.00	QC21		DAS 21 9-89

Primer 1389C2 Paint 138956

NOV 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.050	6061-T6 .050 Sheet	.8000 sf (.08 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.050	1	101	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	0.250Inches $\pm$ 0.030	0.280 0.220	0,251	
2	Shim	0.250Inches $\pm$ 0.030	0.280 0.220	0,250	
3	Shim	2.650Inches $\pm$ 0.030	2.680 2.620	2,648	
4	Shim	4.250Inches $\pm$ 0.030	4.280 4.220	4,251	
5	Shim	0.098Inches + 0.004 - 0.001	0.102 0.097	9099	Diameter
6	Shim	0.050Inches $\pm$ 0.010	0.060	0,049	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐	
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation						Disposition					
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/13/18 Container No: S091791 Part: D5305-1 Job No: 180276 Serial No/Batch: S091791 Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ Other Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Other Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Other Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐										Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Deviation				Disposition			Completed By																		
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			